



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB T103347-101-115
Job Sheet 195057



Part No: RB T103347-101-115

Job Qty: 5 pcs

Part Name: Base



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/13/19

Job Tracking No:

Due Date: 6/21/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB T103347-101 Rev 2 IPP Rev. A 19.05.07 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Omax - 1	5 pcs	6/21/19	6/21/19	0.25	1.25	Waterjet - Omax		a19/06/21
110	QC 2	5 pcs	6/21/19	6/21/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		a19/06/21
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		



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CANADA
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Container No: S192762



Part: RB T103347-101-115

Job No: 195057

Serial No/Batch: S192762

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 07/22/19

120	HAAS 4 Axis - B4B	5 pcs	6/21/19	0.00 2.50	QC 2 - 5	
					QC 2 - 71	
					HAAS - 1 - B4B	WV-5000-1 J-L-L 10-10-19
					HAAS - 2 - B4B	
					HAAS - 3 - B4B	
130	QC 2	5 pcs	6/21/19	0.00 0.00	HAAS - 4 - B4B	
					QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
140	QC 8	5 pcs	6/21/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	

				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
150	Outsource - 4 - Anodize	5 pcs	6/21/19	GRO002-VC	<i>2019-07-12</i>
160	Packaging 2-1 - Receive - B4B	5 pcs	6/21/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B
170	QC 6	5 pcs	6/21/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
180	Packaging 3-1 - Stock - B4B	5 pcs	6/21/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B

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				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	5 pcs	6/21/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-85
Part Op 100 - Waterjet 2 OMAX (Waterjet 2) 1-Cut as per DWG. DWG. Rev: <u>2</u> PROG. Rev: <u>2</u> Holes will be Descriptions: drilled and taped at machining. 2-Deburr if necessary 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - 1-Machine as per folio FC <u>NIA</u> FOLIO REV: <u>NIA</u> DWG REV: <u>2</u> Drill and tap holes. 2-Deburr 140 - (QC8- Inspect parts - second check) 150 - -Issue P/O; <u>43995</u> -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant - Material type; 6061T6 -Certificate of Conformity is required 160 - (Receive & Inspect for Damage & Mat'l Certs) 170 - (QC6- All purchased or subcontracted products) 180 - (Identify as per dwg & Stock Location: _____) 190 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6S.375	6061T6 Sheet, .375	9.3000 sf (1.86 ea)	100-Waterjet - Omax - 1	5144618	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Omax - 1	M6061T6S.375	9	16	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order: 195057
Description: Base		Part Number:
Inspection Dwg: RBT103347-101-115 Rev: 2		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
13.2	+/- .100	13.2	✓		Viper-01	
20.3	+/- .100	20.3	✓		Viper-02	
10.7	+/- .100	10.7	✓		Top	
10.1	+/- .100	10.1	✓			
11.2	+/- .100	11.2	✓			
4.25	+/- .010	4.248	✓			
7.62	+/- .010	7.622	✓			
9.62	+/- .010	9.626	✓			
6.20	+/- .010	6.20	✓			
14.62	+/- .010	14.62	✓			
0.80	1/10.010	.610	✓		Caliper	JCL-09
3.85	1/10.010	3.860	✓			
4.98	1/10.010	4.490	✓			
1/16.20 hole	30	17.050K	✓		60- No 60	
10.81	1/10.010	10.815	✓		Caliper	
8.43	1/10.010	8.433	✓			
.60	1/10.010	.610	✓			
4.98	1/10.010	4.99	✓			
Ø .1875	±0.0005	.1875	✓		Pin Gauge	
10.05	1/10.010	10.057	✓		Caliper	
9.18	1/10.010	9.183	✓			
8.25	1/10.010	8.260	✓			
19.56	1/10.010	19.580	✓			
12.70	1/10.010	12.703	✓			
11.780	1/10.005	11.782	✓			
Ø 0.375	1/10.0005	.375	✓		Pin Gauge	
Ø 3.0	±0.01	3.002	✓			

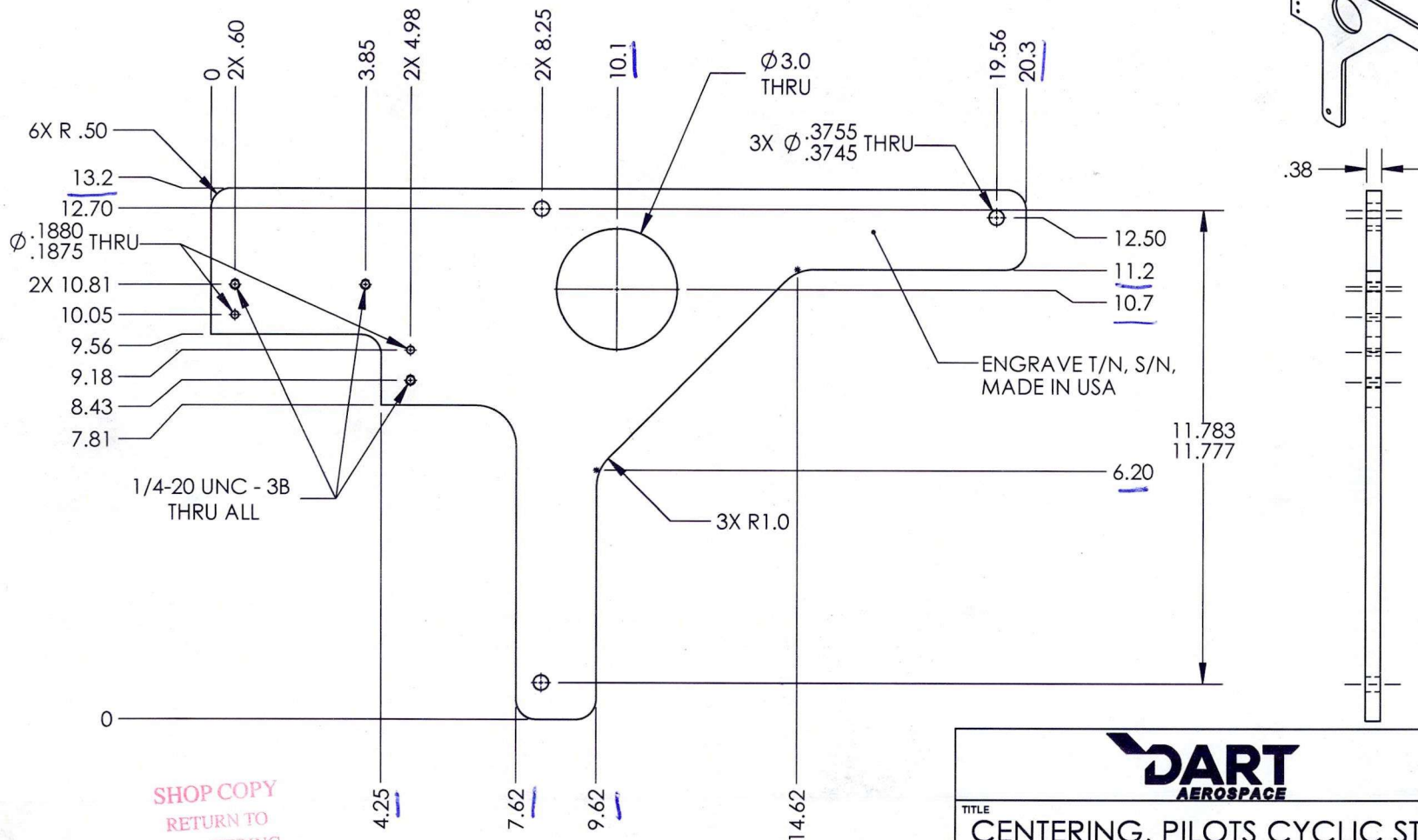
Measured by: <i>an/5.5-L</i>	Checked by: <i>Inf</i>	QC Inspector:
Date: 19/06/21	Date: 19/07/12	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-115 CH'D LIMIT DIM WAS Ø.1875-.1870 IS .1875-.1880.	6/16/2014	DPD	RJC
2	15-0197	-115 ADDED ENGRAVE T/N, S/N, MADE IN USA NOTE.	8/5/2015	RJC	JAG



SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 195057 MJS
190577

(-115)
BASE

DART AEROSPACE	
TITLE CENTERING, PILOTS CYCLIC STICK	
DWG NO. RB T103347-101-115	REV 2
MAT'L 6061	DRAWN BY: DUERFELDT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED D Weill
.XXX ± .010 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .03 ANGLES ± 5°	FINISH CHEM FILM
.X ± .1	SPEC CLASS 1A
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL BELL 412
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:4	DATE 6/12/2014
SHEET 3 OF 9	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		Other/Details: _____ _____ _____			



Container No: S192762



Part: RB T103347-101-115

Job No: 195057

Serial No/Batch: S192762

Revision: 2

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/21/19



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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Tel (613) 632-5200

PURCHASE ORDER

POHB043995



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043995

PO Date: 7/12/19

Due Date: 7/22/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-07-16

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	195057	RB T103347- 101-115	Base -Issue P/O; _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	7/22/19	6 pcs	0 pcs	6 pcs	\$20.00/pcs	\$120.00
Grand Total:											\$120.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/16/19 8:20 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(020732-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

020732-1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courrier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
17-Jul-2019		SVETLANA DORZHIYEVA				POHB043995 ✓			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)		CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty Qté Scrap/ À venir / Back Order		
1	RBT103347-101-115 ✓ Rev.	RBT103347-101-115 ANO-CLEAR [ANODIZE CLEAR] AS PER IAW MIL-A-8625F TYPE 2, CLASS 1 WATER SEALANT		ANODIZE CH	6	6	0	0	0
RECEIVED JUL 19 2019 DART AEROSPACE LTD. DAS 61 9-89									

DAS
61
9-89

RECEIVED

JUL 19 2019

DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

J. JAY

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.